ATI

AMERICAN TACTICAL IMPORTS

OWNERS MANUAL

⚠ WARNING

BEFORE USING THIS FIREARM;
COMPLETELY READ AND FOLLOW THESE INSTRUCTIONS

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WARNING

If this firearm is carelessly or improperly handled, unintentional discharge could result and could cause personal injury, death or damage to property. FOR YOUR SAFETY AND THE SAFETY OF OTHERS, this Operations Manual contains important instructions, warnings and safety procedures that must be understood BEFORE using your American Tactical firearm. It is imperative that you read the ENTIRE MANUAL and if you do not understand any part of it or the operation of your American Tactical firearm, you should seek professional firearms instruction.

NOTICE

American Tactical Imports shall not be responsible for personal injury, death or damage to property resulting from either intentional or accidental discharge of this firearm, or from its function when used for purposes or subjected to treatment for which it was not designed. American Tactical Imports will not honor claims involving this firearm which result from careless or improper handling, unauthorized adjustment or parts replacement, corrosion, neglect, or the use of wrong caliber ammunition, other than original high quality commercially manufactured ammunition in good condition, or any combination thereof. American Tactical Imports will not honor claims involving this firearm for any reason or cause when the second or subsequent owner makes such claims. Before the rifle left the factory, this firearm was tested, carefully inspected and packaged. American Tactical Imports cannot control product handling after it leaves our warehouse; therefore please examine this firearm carefully at the time of purchase to ensure that it is unloaded and undamaged.

WARNING

Children are attracted to and can operate firearms that can cause severe injuries or death. Prevent child access by always keeping guns locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison.

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ADVERTENCA

A los niños los atrean las armas de fuego y las pueden hacer funcionar. Ellos pueden causarse lesiones graves y la muerta. Evite que los niños tengan acceso a las armas de fuego guardándolas siemprecon llave y descargadas cuando no las este utilizando. Si usted tiene una arma de fuego cargada en un luger en que un niño tiene acceso a ella y la usa indebidamente, le pueden dar una multa o enviarle a la cárcel.

GENERAL HANDLING CAUTIONS

1. Do NOT alter or modify your firearm, and DO have it serviced regularly!
2. Always handle your firearm as if it were loaded.
3. Never point your firearm at anything you don't intend to shoot.
4. Always make sure your firearm is not loaded and the bolt is latched open and to the rear before laying it down or handing it to someone.
5. Never leave a loaded firearm unattended.
6. Always be sure bore, muzzle, chamber and action are clear of obstruction.
7. Always check that ammunition is clean and undamaged.
8. Never drink alcoholic beverages or take drugs before or during shooting.
9. Always wear eye and ear protection when shooting.
10. Always keep safety on "SAFE" when the firearm is loaded and a cartridge is chambered until ready to shoot.
11. Never attempt to fire if water is in the bore.
12. Never indulge in "horseplay" when holding your firearm.

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GENERAL HANDLING CAUTIONS CONTINUED

13. Be sure the cam pin is installed in the bolt group. If it isn't, your rifle can still fire and it could possibly explode, causing you personal injury or harm.
14. DO NOT exchange or switch bolt assemblies from one rifle to another. It could cause personal injury to you and others and damages your rifle.
15. If your Firearm fails to fire, hold it, keep it pointed towards the target and wait 30 seconds. If a hangfire has occurred the round will fire within 30 seconds. If the round does not fire, remove magazine, eject round and examine the primer. If firing pin indent is light, misaligned or non-existent, have your firearm examined by a competent gunsmith. If firing pin indent on primer appears normal (in comparison to previously fired rounds) assume faulty ammunition; appropriately dispose of misfired round from other live ammunition; reload and assume firing.

USE OF SAFETY SELECTOR

A selector lever, located on the left of lower receiver, has two positions, "FIRE" and "SAFE". When set to "FIRE", the firearm will fire a single shot each time the trigger is squeezed. When set to "SAFE", a cam bears upon the rear of the trigger, blocking movements and preventing the hammer from being released.

FUNCTION CHECK

SAFE NOTE: REMOVE MAGAZINE AND MAKE SURE YOUR RIFLE IS UNLOADED AND THERE IS NO AMMUNITION IN THE CHAMBER. Point in safe direction. Pull charging handle to rear and release. Place on safe. Pull Trigger. Hammer should not fall.

FIRE NOTE: REMOVE MAGAZINE AND MAKE SURE YOUR RIFLE IS UNLOADED AND THERE IS NO AMMUNITION IN THE CHAMBER. Point in safe direction. Place selector on fire. Pull trigger and hold to rear. Hammer should fall. Pull charging handle to rear and release. Release trigger and pull again. Hammer should fall

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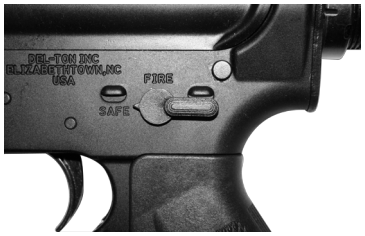
SAFETY FEATURES

The following sections contain caliber specific information. Please open to the section relevant to your particular rifle's caliber. If you are unsure of the caliber of the rifle, the caliber marking can be found on the barrel of the rifle, immediately in front of the gas block on the bottom of the barrel.

"SAFE"

Rifle will not fire. Selector lever cannot be on safe unless rifle is cocked. Always place on SAFE when loading and unloading.



"FIRE"

Rifle will fire one round each time the trigger is pulled.

DISCONNECTER

The disconnecter, a part of the firing mechanism, prevents the firearm from firing full automatic. As the hammer is cocked after each shot, the disconnecter holds the hammer until the trigger is released. When the trigger is released, retention of hammer passes from disconnecter to trigger ready for the next shot.

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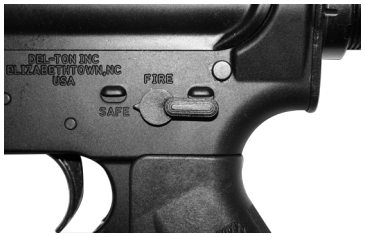

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FIRING PIN COLLAR

The bolt carrier assembly, located within the upper receiver, is designed to prevent the firing pin from striking a cartridge until the bolt is locked to the barrel.

.223 REM.
7.62 x 39mm

SIGHTS

1. Rear sight can be adjusted for both windage and elevation and has a dual aperture peep sight, one for short range and one for long range.
2. When flipped forward, the aperture is marked 0-2 for zero to 200 meters. When using this setting, the elevation knob should be set at 8/3 low or 6/3 for detachable carry handle or flat top rear sights. This is its lowest position.
3. When the aperture is flipped back, it is set for using the long range sight. When using this setting, you can adjust the elevation knob for range required: 8/3 low for 300m, 4 for 4oom, 5 for 500m, 6 for 600m, 7 for 700m, and 8/3 high for 800m. There are click settings in between for fine tuning.
4. The windage knob is located on the right side of the rear sight. To adjust for horizontal movement on target, turn knob clockwise for right and counter-clockwise for left.
5. The front sight is adjustable for elevation zeroing only.

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ZEROING SIGHTS

This procedure is for .223 ammunition. The procedure described is for zeroing at 25 meters but may be adjusted accordingly for longer ranges. The following table shows change of impact per click at specific range.

WINDAGE:	25m 3/8in.	
	100m 1 3/8in.	
	200m 2 3/8in.	
ELEVATION:	25m 1/8in.	800m 4in.
	100m 1/2in.	500m 2 1/2in.
	200m 1in.	600m 3in.
	300m 1 1/2in.	700m 3 1/2in.
	400m 2in.	

FRONT SIGHT - To adjust elevation, depress detent, rotate post. To raise the strike of the bullet, rotate post in the direction of arrow marked up. Reverse the direction of rotation to lower strike of bullet. Each graduation (notch) moves the point of impact of bullet as indicated in chart.
SIGHT POST
SPRING-LOADED DETENT

.223 CALIBER
ZEROING SIGHTS

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SPRING-LOADED DETENT

.223 CALIBER
ZEROING SIGHTS

1. Set elevation to 8/3 low or 6/3 for detachable carry handle and flat top rear sights, then raise it one click. No further adjustment should be made during zeroing.

2. Flip aperture to small long range sight
3. Set aperture to mechanical zero by adjusting windage until sight is aligned with center line on scale under sight
4. Carefully aim and fire at bull's-eye on target at 25 meters: Fire ten rounds to establish group
5. Compare group with bull's eye, if they match, no further adjustment is necessary
6. If group does not match bull's-eye, measure vertical and horizontal distance from bull's-eye
7. Calculate clicks of windage required to move impact appropriate distance. Turn windage knob accordingly. (see chart on page 6 for 25m windage clicks)
8. Calculate clicks of front sight required to raise or lower impact appropriate distance. (1 click = 3/8in. at 25m)
9. Depress plunger and front sight required number of clicks. Clockwise will lower sight and raise impact, and counter-clockwise will raise sight and lower impact.
10. Set elevation knob back to 8/3 or 6/3 low and flip aperture back to 0-2 for ranges 0-200m.

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BATTLESIGHT ZERO

TO ZERO THE RIFLE, YOU MUST HAVE THE FRONT SIGHT (ELEVATION) AND THE REAR SIGHT (WINDAGE) ADJUSTED SO THAT IT CAN HIT YOUR POINT OF AIM AT A GIVEN RANGE.

NOTE:
TO battlesight zero your rifle, you adjust your sights so you can hit an aiming point at 250 meters. Zeroing can also be accomplished on a 25 meter range by adjusting the sights so that the bullet will strike 2.4 centimeters below the point of aim.
TRAJECTORY
POINT OF AIM
2.4CM BELOW
STRIKE OF
25M BULLET 250M
LINE OF SIGHT

.223 CALIBER
LOADING
TO LOAD A MAGAZINE...

1. Use only ammunition for which your firearm is chambered.
2. With front of magazine forward, place a round between the lips of the magazine with the bullet forward. Press the round down until it is retained by the magazine lips. Place the next round on top of the last and repeat until desired number is loaded.

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TO LOAD THE RIFLE...

1. Press in on bottom catch while pushing back on charging handle, to cock the hammer and leave the bolt and carrier to the rear.
2. Return the charging handle to fully forward until it locks and remove finger from bolt catch.
3. Set selector to "SAFE" position.
4. With the bullets pointing forward, insert loaded magazine into magazine well and push it in until it stops and is retained by magazine catch.
5. With the rifle pointed in a safe direction, press in on top of bolt catch. This will release the bolt and carrier and move a round into the chamber. The rifle is now loaded with a round in the chamber and the hammer cocked.
6. You may now close the ejection port cover it you wish; it is located on the right side of the upper receiver and will open automatically when the first round is fired.

TO UNLOAD THE RIFLE...

1. Set selector to "SAFE" position.
2. Press magazine catch button and remove magazine.
3. Pull charging handle to rear and push in lower portion of bolt catch. If a round had been in chamber, it should have been ejected. If last round in magazine had been fired and if the magazine was in place, bolt and carrier should already be held to the rear.

CAUTION: Always check the ammunition is clean and undamaged before using the forward assist.

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Forcing damaged ammunition into the chamber could result in personal injury or death to you and others and damage your rifle and property. The use of reloaded, hand-loaded or high pressure ammunition can be dangerous and will void the warranty.

Make sure the rifle is pointed in a safe direction and the safety is engaged at all times while loading the rifle.
NEVER allow your fingers or other objects to contact the trigger while loading or unloading the rifle.
Do NOT disengage the safety until you are ready to fire and have the rifle pointed safely downrange.

.223 CALIBER
CLEAN YOUR RIFLE

1. Place selector on "SAFE". If weapon is not cocked, lever cannot be pointed toward "SAFE".
2. Remove Magazine.
3. To lock bolt open, pull charging handle rearward, press button of bolt catch and allow bolt to move forward until it engages in bolt catch. Return charging handle forward. If you haven't before, place on "SAFE".

4. Eyeball receiver and chamber to ensure these areas contain no ammo.
5. With selector lever pointing toward "SAFE", allow bolt to go forward by pressing upper portion of bolt catch.

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FIRING

NEVER load a cartridge into a chamber until you are ready to fire the rifle. Do NOT disengage the safety until the rifle is pointed in a safe direction and you are ready to fire.

TO FIRE...

1. Always wear ear and eye protection when firing your weapon.
2. Load firearm as previously described.
3. Set rear sight to range required.
4. Grasp firearm with one hand on hand guard and the other on pistol grip with trigger finger resting along side of trigger guard. Raise firearm and pull buttstock firmly into shoulder.
5. Aim by aligning target with front and rear sights.
6. Move selector lever to "FIRE"
7. Keeping steady aim, place trigger finger on trigger and squeeze gently until trigger releases hammer. Do not jerk the trigger as you will disturb your aim and ruin your accuracy. To fire the next round and subsequent rounds, all that is necessary is release the trigger and squeeze it again after every shot until you are finished or the magazine is emptied.
8. This is a semi-automatic firearm and is immediately loaded and ready to fire after each shot until magazine is empty.
9. Release trigger, remove finger from trigger, and set selector lever to "SAFE". If you have fired the last round from the magazine, the bolt and carrier will be held to the rear so that you can quickly reload by replacing the magazine and/or checking the chamber to ensure it is empty. Before firing your rifle, practice your stance, rhythm and breathing for steady aim with your firearm unloaded. Practice firing on a range before going hunting or using your firearm for any other type of shooting.

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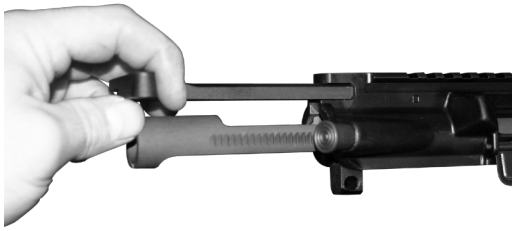
MAINTENANCE

Your American Tactical rifle is based on military rifle design and is very rugged, but proper maintenance is necessary to keep it in good working condition.

FIELD STRIPPING/DISASSEMBLY

1. **Press down pin in from left of lower receiver (it may be necessary to use a punch as the fit between upper and lower may be very tight). Pull it out the right side until it comes to a positive stop.**
2. **Pivot lower receiver down and away from upper portion of receiver.**

3. **Press front pivot pin in from left side of lower receiver and pull out right side until it comes to a positive stop.**
4. **You can now separate the upper and lower receivers.**
5. **Pull charging handle to rear and remove bolt and carrier assembly.**



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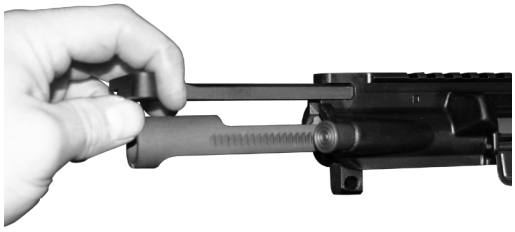

6. Remove charging handle by pulling it backwards to key way and down out of receiver.
7. Push in firing pin retaining pin right-to-left of bolt carrier and remove it by pulling it out to the left.

8. Tilt bolt face up and remove the firing pin.

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9. Push bolt in towards the carrier until it rotates and comes to a stop, then turn cam pin 90°.

10. Remove cam pin by lifting it out away from bolt and carrier.
11. Pull bolt forward out of carrier.
12. Depress buffer, maintaining pressure as buffer is under spring tensions, to prevent it from being ejected when buffer retainer is depressed. Depress buffer retainer to permit buffer and spring to move forward. Then depress hammer to allow the buffer and spring to continue to move forward and be removed from receiver extension.
13. With a punch, remove the extractor pin from the bolt assembly.
14. Remove the extractor and spring. DO NOT remove the spring from the extractor.
15. Press top of extractor spring rubber tip to test spring function.
16. To remove handguards, push delta ring towards receiver while pulling up on half of the handguard. Repeat process for other half of handguard.

NOTE: Do not strip your firearm further than previously described.

9. Push bolt in towards the carrier until it rotates and comes to a stop, then turn cam pin 90°.

10. Remove cam pin by lifting it out away from bolt and carrier.
11. Pull bolt forward out of carrier.
12. Depress buffer, maintaining pressure as buffer is under spring tensions, to prevent it from being ejected when buffer retainer is depressed. Depress buffer retainer to permit buffer and spring to move forward. Then depress hammer to allow the buffer and spring to continue to move forward and be removed from receiver extension.
13. With a punch, remove the extractor pin from the bolt assembly.
14. Remove the extractor and spring. DO NOT remove the spring from the extractor.
15. Press top of extractor spring rubber tip to test spring function.
16. To remove handguards, push delta ring towards receiver while pulling up on half of the handguard. Repeat process for other half of handguard.

NOTE: Do not strip your firearm further than previously described.

Your rifle is now field stripped for cleaning. To reassemble, repeat procedure in reverse order.
STOP FURTHER DISASSEMBLY SHOULD ONLY BE PERFORMED BY AN AMERICAN TACTICAL GUNSMITH.

.223 CALIBER
THOROUGH CLEANING
UPPER RECEIVER
CLEAN WITH RBC
(Rifle Bore Cleaner)
Be sure to include:

- All areas of powder fouling, corrosion, dirt and rust
- Bore & chamber
- Locking lugs
- Gas tube

Use a worn bore brush to get outside surface of protruding gas tube (get sides and bottom from bottom of receiver).

BOLT CARRIER GROUP
Be sure to include:

- Outer & inner surfaces of bolt carrier
- Carrier key
- Firing pin recess and firing pin
- Firing pin hole (Use pipe cleaner there)
- Areas behind ring and under lip of extractor

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.223 CALIBER
THOROUGH CLEANING
LOWER RECEIVER GROUP

- Clean areas of powder fouling, corrosion and dirt
- Wipe dirt from trigger mechanism
- Clean buffer and inside lower receiver extension

CAUTION
DO NOT USE WIRE BRUSH OR ANY TYPE OF ABRASIVE MATERIAL TO CLEAN ALUMINUM SURFACES.

CLEAN...INSPECT...LUBE
With the rifle disassembled, thoroughly clean, inspect and lube so you have a reliable weapon you can always depend on. After firing, clean your weapon for 3 consecutive days with Rifle Bore Cleaner (RBC). Wipe dry and lube according to lubrication instructions.

IF ANY PARTS ARE MISSING OR DEFECTIVE CONTACT AMERICAN TACTICAL IMPORTS.
100 Airpark Drive · Rochester, NY 14624 · 800-290-0065 · Fax 585-328-4168 · www.Americantactical.us

.223 CALIBER
LUBRICATING GUIDE
LIGHTLY LUBE - A film of oil barely visible to the eye.
GENEROUSLY LUBE - Heavy enough so that it can be spread with a finger.
REMEMBER TO REMOVE EXCESSIVE OIL FROM THE BORE BEFORE SPREADING.

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LUBRICATING

UPPER RECEIVER

LIGHTLY LUBE:

Bore & chamber, outer surfaces of barrel and front sight, surfaces under handguard, depress front sight detent several times to work lube into spring.

START AT RECEIVER , GO RIGHT THROUGH COMPENSATOR (DON'T REVERSE DIRECTIONS IN BORE)

BOLT CARRIER GROUP

GENEROUSLY LUBE outside of these parts:

Make certain to get cam pin area, piston rings, and outside of the bolt body.

CAUTION:

LIGHTLY LUBE FIRING PIN AND FIRING PIN RECESS IN BOLT.

DRY WITH PIPE CLEANER, THEN PLACE ONE DROP OIL ON CARRIER KEY

LIGHTLY LUBE: Charging handle, inner and outer surfaces of bolt carrier.

GENEROUSLY LUBE: Slide and cam pin area of bolt.

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.223 CALIBER
LUBRICATING
LOWER RECEIVER GROUP
GENEROUSLY LUBE:
Take down and pivot pins, INSIDE PARTS, LOWER RECEIVER BUFFER, action spring, inside lower receiver extension

INSPECT BEFORE ASSEMBLY
WARNING - DO NOT interchange bolts between rifles
BOLT- Cracks or fractures, especially in the cam pin hole area. Bolts that contain pits extending into the firing pin hole need replacing.
FIRING PIN - Replace if it has a bent, cracked or blunted end.
RETAINING PIN - Replace if bent, broken, or badly worn.
CAM PIN - Replace if cracked, chipped or missing.
EXTRACTOR AND EXTRACTOR SPRING - Check extractor for chipped or broken edges in the area of the lip that engages the cartridge rim.
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.223 CALIBER
ASSEMBLY
1. Insert spring and buffer.
2. Insert extractor and spring. New extractor has a silicone insert w/ spring. Be sure not to lose it. If the spring comes loose, put the large end spring in the extractor seat.

.223 CALIBER
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3. Push in extractor pin.
4. Slide bolt into carrier.

WARNING - DO NOT switch bolts between rifles.

STAGGER RING GAPS TO STOP GAS LOSS.

5. Replace bolt cam pin.

WARNING - Be sure that the cam pin is installed in the bolt group. If it isn't, your rifle can still fire and will explode.

6. Drop in seat.

FIRING PIN

7. Pull bolt back.
8. Replace retaining pin.

NOTE - Firing pin should not fall out when bolt carrier group is turned upside down

.223 CALIBER

ASSEMBLY

9. Engage, then push charging handle part way.
10. BE SURE BOLT IS STILL UNLOCKED - Slide in bolt carrier group.
11. Push in charging handle and bolt carrier group together.
12. Join upper and lower receivers.
13. Engage receiver pivot pin.
14. Close upper and lower receiver groups. Push in takedown pin.

CAUTION - Selector lever must be on safe before closing upper receiver.

15. Put hanguards in place. HOLD DOWN DELTA RING CHECK FOR FULL ENGAGEMENT.
16. Snap on sling.

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.223 CALIBER
UNUSUAL CONDITIONS

EXTREME COLD -

- Clean and lubricate rifle with gun lubricant, keep it moisture-free.
- Operate controls though their entire range, at intervals, to keep them from freezing up.
- When your rifle is not being used and outside, protect it with a cover.

HOT CLIMATES -

- Inspect rifle and bipod more frequently, especially the hidden surfaces of bolt carrier group, forward assist assembly and lower receiver components. Make certain they are lubricated using gun lubricant.
- When handling, make certain to wipe dry, as moisture could cause corrosion.

After drying, lubricate with gun lubricant.

HOT, DRY CLIMATES -

Clean and oil rifle more frequently with gun lubricant.

DUSTY AND SANDY AREAS -

- Clean and lubricate your rifle more frequently.
- Keep sand out of parts when inspecting, lubricating, or assembling rifle. Apply only a very light amount of lubrication on outside of rifle.
- Use magazine bag and muzzle cap for dust and sand protection.

CAUTION: Do not use magazine bag and muzzle cap on stored rifles.

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PROJECTILE LODGED IN BORE

WARNING

If an audible "POP" or reduced RECOIL is experienced during firing, immediately CEASE FIRE, remove the magazine (1), lock the bolt to the rear (2), and place the selector lever on the "SAFE" position (3). Visually inspect and/or insert a cleaning rod into the bore to ensure there is not a projectile lodged in the bore (4).

DO NOT APPLY IMMEDIATE ACTION -

If a projectile is lodged in the barrel of the weapon, DO NOT attempt to remove it. Contact American Tactical Imports.

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